

Work Order ID 66566

Tuesday, February 22, 2011 10:26:45 AM



Page 1

Item ID: D2958

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 2/23/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *MUF*

Date: *11-02-22*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2958	Rev E

100		0.00
-----	--	------



FLOW WATER JET

Waterjet Memo

FLOW CNC Waterjet

F
F
1

0.00

B11-3-1

(16)

110		0.00
-----	--	------



QC2- Inspect parts off machine FAI/FAIB

QC Memo

Quality Control

0.00

B11-3-1

120		0.00
-----	--	------



QC8- Inspect parts - second check

QC Memo

Quality Control

0.00

8/11/03/02

(410)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

SPC (Y/N):

Date:

Stop

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130



Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg D2958 and Folio FTA005 □ Dwg.
Rev. E □ Folio Rev. B

0.00

0.00

x 10

Dh
11/03/03

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Check product for scratches mal-formation or any other non conformances.

0.00

0.00

x 10

Dh
11/03/03

150



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

11 03 03 (10)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Thermoform

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required ☐ Wrap in protective film

x/0

DL
11/03/03

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

11 03 03 (10)

180



Packaging

Identify as per dwg & Stock Location 2/4

0.00

Memo

0.00

Packaging

11/3/4 102/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/11

MF
11-0307

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, February 22, 2011 10:26:43 AM

Page 1

Work Order ID: 66566



Parent Item: D2958



Parent Item Name: Window

Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP E: 01.09.25 ☐ Done by outside contract ☐ SM
IPP F: 07.06.26 Thermoform in house DL
IPP G: 07.09.28 Rev E dwg EC verified by: DD
IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 		Purchased	No			100	sf	128.4222	2.58	21.72632		30,	
1/8" Polycast II Sheet											1811-3-1		

Location

Loc Qty

Loc Code

MAT

128.4222

114673

1.1722

115338

127.25

115338

10

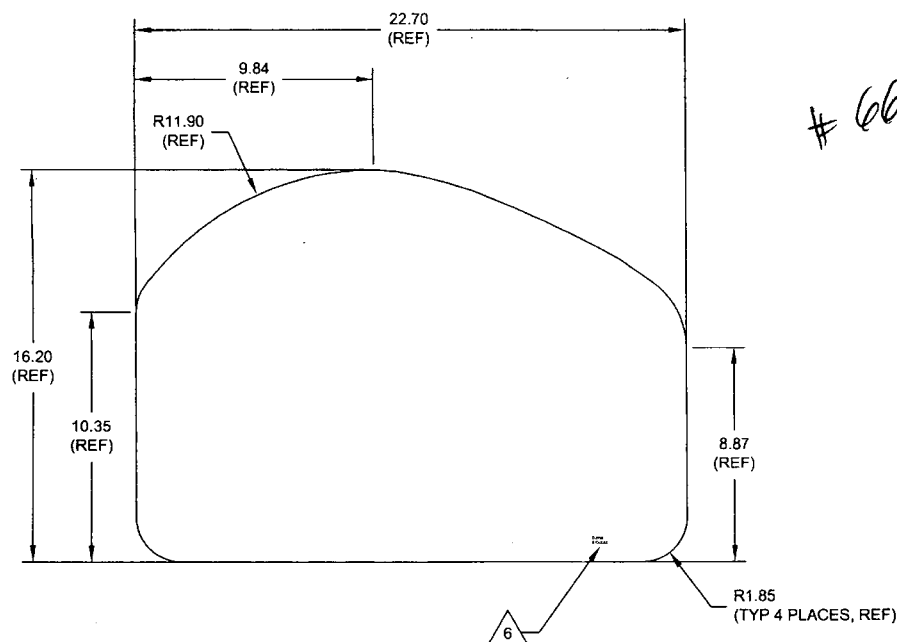
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D2958 FLAT PATTERN

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

RELEASED
07.07.22

E	UPDATE DIMS PER PAR 168	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2958	REV. E
TITLE WINDOW	SHEET 1 OF 1
	SCALE 1:5

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